Work Order ID 73623

Wednesday, September 07, 2011 2:39:44 PM

Item ID:

D3453-5

Revision ID:

Item Name: Plug

Start Date:

9/7/2011

Required Date: 9/21/2011

Start Qty: 10.00 Req'd Qty: 10.00

Accept

Setup Start

Page 1

Stop

Reference:

Approvals:

Process Plan:

QC:

Date:

Tooling:

0.00

Date:

SPC (Y/N):

Set Up/ **Run Hours** Date:

Cust Item ID:

Customer:

Tool ID

Date:

Tool # Plan

Code

Run Start

Reject

Qty

Accept

Qty

Stop



Insp.

Stamp

Reject

Number

Sequence ID/

Operation Work Center ID Description **Revision Nbr**

Draw Nbr

D3453

100

Doosan

Doosan Lathe

DOOSAN LATHE

0.00

I-TURN AS PER FOLIO FA581 & DWG D3453, FOLIO

REV¶ JA □DWG REV: 2-DEBURR AS REQUIRED

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

QC8- Inspect parts - second check

0.00

QC

120

Quality Control

Memo

0.00

Dart Aerospace	Lta
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W/O:		WORK ORDER C	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No):	PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date: _			

	R	esolution:	Disposit	tion: Q	A: N/C Clos	sed:	Date: _	<u>.</u>
NCR:		\	WORK OR	DER NON-CONFORMANC	E (NCR)	· · · · · · · · · · · · · · · · · · ·		
	T	Description of NC	Corrective Action Section B			Verification A		Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	QC Inspector
							·	
							, 	

NOTE: Date & initial all entries

Work Order ID 73623

Wednesday, September 07, 2011 2:39:44 PM

Item ID:

D3453-5

Revision ID: Item Name:

Plug

Start Date:

9/7/2011

Required Date: 9/21/2011

Start Qty: 10.00 Req'd Qty: 10.00

Reference:

Sequence ID/

130

Packaging

Work Center ID

Process Plan: Approvals:

QC:

Tooling:

Date:

Date:

SPC (Y/N):

Accept

Set Up/ **Run Hours**

Identify as per dwg & Stock Location: TUGE

Operation Description

Memo

0.00

Packaging

140

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Setup Start



Cust Item ID:

Customer:

Tool ID

Date:

Date:

Run

Start

Stop

Stop



Tool # Plan

Code

Accept Qty

Reject Qty

Reject Number Insp.

Stamp

10x 88 11-105

n/10/6 \$

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					* *			
W/O:			WORK ORDER (CHANGES				. •
DATE	STEP	1	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		·						
				·				
Part No):	PAR #:	Fault Category:	NCR: Ye	s No DQ	A:	Date: _	
	Re	esolution:	Disposition:	QA: N/C	Closed:		Date: _	
	· · · · I		WORK OPPED NON CON	EODMANCE (NO	<u>'0'</u>			

NCR:		WORK ORDER NON-CONFORMANCE (NCR)										
		Description of NC		Corrective Action Section B		Verification	Approval	Approval QC Inspector				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng					
							,	1				
•												

NOTE: Date & initial all entries

Picklist Print

Wednesday, September 07, 2011 2:39:42 PM

Work Order ID: 73623

Parent Item:

D3453-5

Parent Item Name: Plug



Start Date: 9/7/2011

Start Qty: 10.00

Required Date: 9/21/2011

Required Qty: 10.00

Comments:

IPP REV. A 05.11.16

NEW ISSUE EC

IPP Rev:B

Now on Doosan Lathe 08-06-05 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R1.000		Purchased	No			100	f	57.9500	0.165	1.736842			
										CP	. 11	11010) 4
304 round bar 1.00										3.	• •	_	,

<u>Location</u>	Loc Qty	Loc Code
MAT029	57.95	
109508	12.5	
109541	0.08	
9113457	45.37	

Page 1

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W/O:			WORK ORDER (WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By Date Qty o	By Date	Approval Chief Eng / Prod Mgr	Approval QC Inspector.		
	_1						L	<u> </u>	
Part No):	PAR #:	Fault Category:	NCR: `	res No	DQA:	Date: _	<u>_</u>	
	F	Resolution:	Disposition:	QA: N	C Closed	l:	Date: _		

NCR:	•	WORK ORDER NON-CONFORMANCE (NCR)										
		Description of NC		Corrective Action Section B	Verification	Approval	Approval					
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector				
												
				· •								
	ate & initial a											

DART AEROSPACE LTD	Work Order:	73623
Description: Plug	Part Number:	D3453-5
Inspection Dwg: D3453 Rev: B		Page 1 of 1

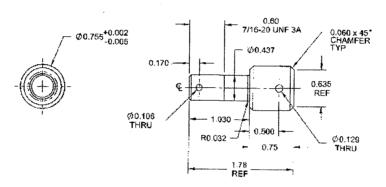
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

	<u> </u>					
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.755	+0.002/-0.005	1. 7545			8/18	
1.030	+/-0.010	1.031				
0.75	+/-0.030	.75R				
0.60	+/-0.030	.630)				
7/16" x 20 UNF	N/A					
0.170	+/-0.010	-172				-1
0.500	+/-0.010	-500)				
Ø0.106	+0.004/-0.001	0.108				:
Ø0.129	+0.005/-0.001	0.131				
Ø0.429 - Ø0.437	N/A	432				
1.281et		1,285.				
		-				
						100
						-
						·
-						
						z.
	<i>A</i>					

Measured by:	A	Audited by:	//	Prototype Approval:	N/A
Date: 11	110/04	Date:	11-10-04	Date:	N/A

Revised by	Approved
	7-7-7-1-1-1
	- <i>u</i>
	KJ/JLM KJ/JLM on revised KJ/DD ↑ ↑



D3453-5 PLUG

D3453-5 NOTES:

1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES. 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 0.13 lbs

DESIGN RF; DART AEROSPACE LTD DRAWN RF HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. B D3453 MFG. APPR. SHEET 2 OF 2 TITLE APPROVED SCALE **CLEVIS** DE APPR. NTS DATE 09.05.21